

Work Order ID 71582

Wednesday, July 06, 2011 1:25:03 PM

Page 1

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 7/6/2011 Start Qty: 12.00

Required Date: 7/20/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: CL

QC:

Date: 7/10/11 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



Waterjet

FLOW WATERJET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

304 .063

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control



Accept



Setup Start

Stop



Cust Item ID:

Customer:

B11-7-11

(12)

B11-7-11

412

5/10/11

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 11/07/12

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

SW 11/07/12

(12)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
22/18/196 Weld hardcoat as per Dwg D3437

EL 11-7-20 (17)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

Pl 11-01-20

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W 11 07 21

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

M 117388

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:20 9:45

10:15

7/7/11 11-7-22

W/O:		WORK ORDER CHANGES					
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Required Date: 7/20/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3-Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: T7 & M 1107(22)

200

Identify as per dwg & Stock Location: *FP*

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 11/7/22 (7x)

210

QC21-Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten: 11/7/22

Handwritten: MF 11-07-22

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Picklist Print

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Work Order ID: 71582

Parent Item: D3537-3

Parent Item Name: Wearpad



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	SF	15.1000	0.149	1.882105			

M304S16GA



304/316 Sheet .063



R16-7-VI

Location

Loc Qty

Loc Code

MAT020

15.1

117275

1.7

117653

13.4

117653

(17)

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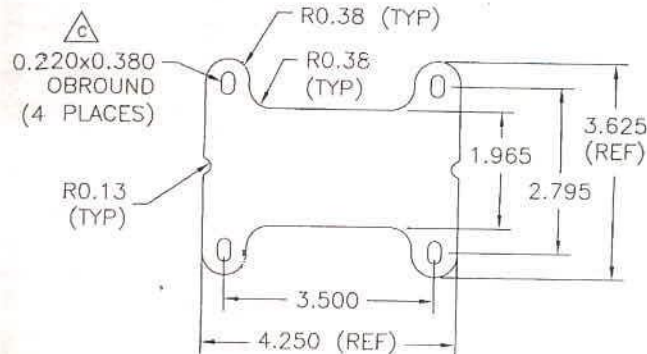
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

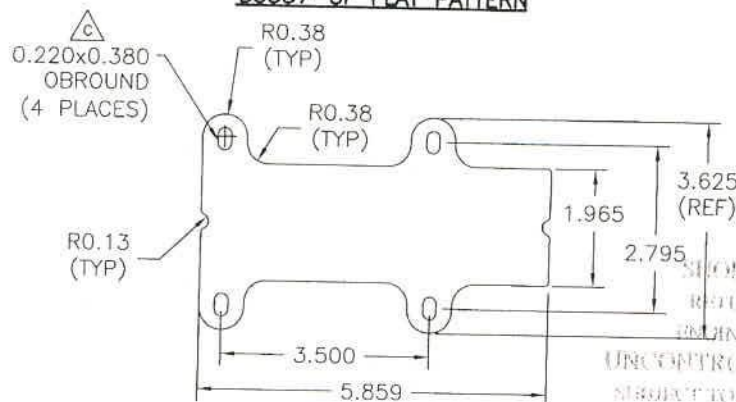
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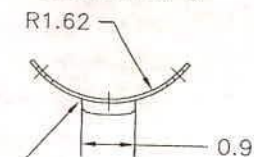
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

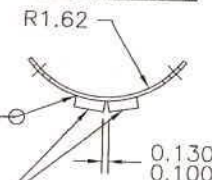


SECTION A-A



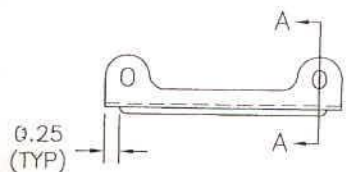
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B

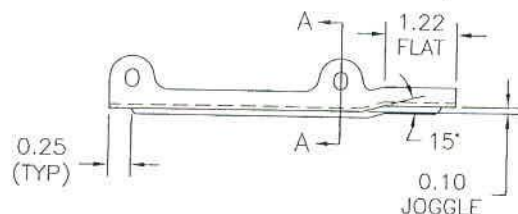


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

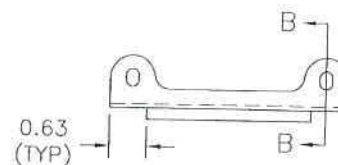
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



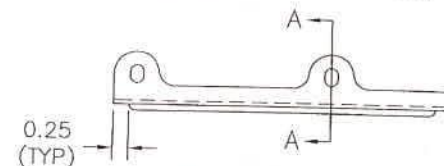
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC.		PORT HADLOCK, MA
REV. C		SHEET 1 OF 1
SCALE		1:2

RELEASED
07.05.08 Ad
per ELN
962

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